












Date: Friday, 14/11/2008 10:21:35 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLUG
Job Number	: 43452		
Estimate Number	: 12338		
P.O. Number	:	Part Number	: D3492045
This Issue	: 14/11/2008 S.O. No. :	Drawing Number	: D3492 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 42478	Material	:
Written By	:	Due Date	: 28/11/2008 Qty: 100 Um: Each
Checked & Approved By	: <u>JLD 08.11.14</u>		
Comment	: Est Rev: A 06.03.21 New Issue JLM : Est Rev: B 06-08-28 As per Rev B JLM : Est Rev: C 07-12-06 as per rev c DD verified by: EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6R0500	6061-T6 Round Bar .500"	
			
Comment: Qty.: 0.0656 f(s)/Unit Total : 6.5625 f(s) 6061-T6 Round Bar .500" (M6061T6R500) Batch: <u>M109396</u> 08/11/17 <u>JD</u> 108 pcs			
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
			
Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Folio FA634 & Dwg D3492 Dwg Rev: <u>C</u> <u>JD</u> 08/11/17 Folio Rev: <u>AA</u> <u>JD</u> 108 pcs			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>JD</u> 08/11/17 <u>JD</u> 108 pcs			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <u>JD</u> 08/11/18 108			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr if necessary 2-Tumble <u>JD</u> 8-11-19 108?			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 14/11/2008 10:21:35 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 43452

Part Number: D3492045

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counters

Comment: INSPECT WORK TO CURRENT STEP

508/11/19

108

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



108

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/11/19

8.0

POWDER COATING

POWDER COATING



M 109 152



108X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
(Flat End Only)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:40
320°F
9:10

M-1 08/11/21

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



108

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/11/24

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: EP-13

M 08-11-25

108

11.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/26

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-26

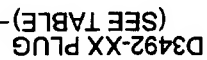
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____




NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X	X					D3492-043	PLUG ASSEMBLY
							D3492-045	PLUG ASSEMBLY
		X					D3492-047	PLUG ASSEMBLY
			X	X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
							NAS1611-013	O-RING
							NAS1611-015	O-RING
							NAS1611-016	O-RING

NOTES:
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05	
B	ADD -047, UPDATE DIM A FOR -045	PH	06.05.11	
A	NEW ISSUE	PH	06.01.04	
REV.	DESCRIPTION	BY	DATE	
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.		PLUG TITLE SCALE 2:1		
DATE				
07.10.05				
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SECRET

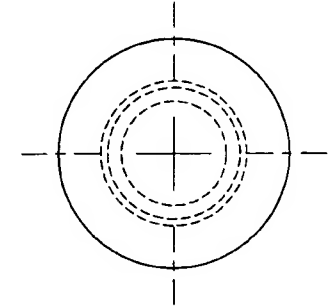
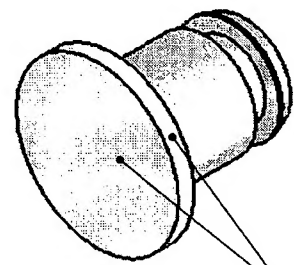
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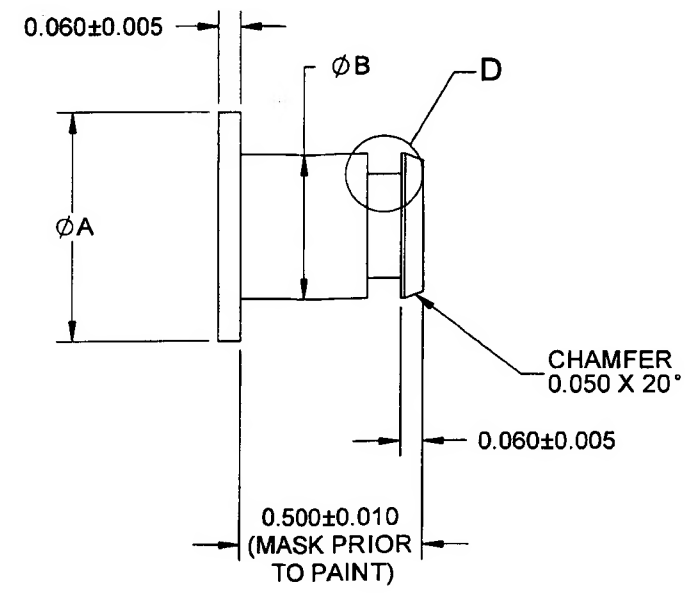
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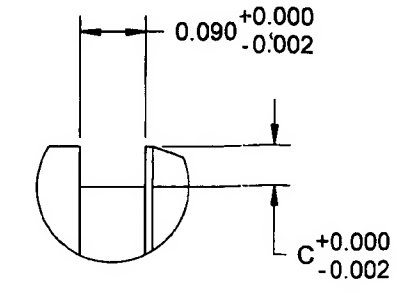
7



POWDER COAT THESE
FACES ONLY PER NOTE 2



D3492-XX PLUG



DETAIL D

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.520	0.045	M6061T6R0.750

- NOTES:**
- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43452

UNDER REVIEW
01.07.11 RFA

DEM AB ON D3492-13
RES. CK (MARE SHAWLER)
ASS 08.11.12
OKay

DEO ATTACHED

RELEASED
07.11.16

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		DRAWING NO. D3492 REV. C
DATE	07.10.05	TITLE PLUG SCALE 4:1
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DRAWING NO. D3492	TITLE PLUG	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3492-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED		DE APPR.		
DATE 08.11.05	DATE 08.11.05	DATE 08.11.05	DATE 08/11/05		DATE 08/11/05		

SHEET 2 MODIFY -13 PLUG AS SHOWN:

IS:

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.510	0.045	M6061T6R0.750

WAS:

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.520	0.045	M6061T6R0.750

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08/11/05